

Date: Wednesday, 6/7/2006 2:37:03 PM
User: Kim Johnston

Process Sheet

19

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OPTIONAL SUPPORT ADDITION
Job Number : 27356
Estimate Number : 11994
P.O. Number : N/A Part Number : DSI 9055011
This Issue : 6/7/2006 S.O. No. : N/A Drawing Number : DSI 9055
Prsht Rev. : NC Project Number : N/A
First Issue : 6/5/2006 Type : R & D SM/MED FAB Drawing Revision : C
Previous Run : Material : N/A
Written By : See Comment Below Due Date : 6/9/2006 Qty: 6 Um: Each
Checked & Approved By : JA 06.06.07
Comment : Est A 06.06.07 New Issue KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Provide photocopy of DSI 9055 CHG002

KS 06-06-07 (6)

2.0 AN420A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Bolt

Batch

M14855 ✓

3.0 MS21042L4 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Nut

Batch

M19085 ✓

4.0 AN960JD416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

Batch

M100575 ✓

5.0 D2171 Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Clamp

Batch

B23371 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: RD Date: 06/06/08

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/7/2006 2:37:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OPTIONAL SUPPORT ADDITION

Job Number: 27356

Part Number: DSI 9055011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2182W035

Rubber Cushion



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Rubber Cushion

Batch

B25013 ✓

7.0

D2274

Radius Block



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Radius Block

Batch

B26078 ✓

8.0

D23623

Step Support Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Step Support Bracket

Batch

B27309 ✓

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

DC

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED	DRAWING NO. DSI 9055	REV. C SHEET 1 OF 2
DATE 06.06.07		TITLE OPTIONAL SUPPORT ADDITION	SCALE NTS
A	96.11.12	NEW ISSUE	
B	99.01.19	NOW REF'D AS -111A INSTALLATION PER TSR A843	
C	06.06.07	ADD KIT TO CONVERT -111 TO -111A	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION DRAWING D350-591 REV. D

REF. CANADIAN STC: SH92-6

REF. FAA STC: SH967NE

A D350-591-111 KIT MAY BE TURNED INTO A D350-591-111A KIT BY INSTALLING THE DSI-9055-011 KIT. THE DSI-9055-011 KIT ADDS A SUPPORT AT THE FORWARD CROSSTUBE TO STRENGTHEN THE STEP AND REDUCE FLEX. THE DSI-9055-011 KIT IS DEFINED BELOW AND SHOULD BE INSTALLED PER THE FIGURES ON PAGE 2 OF THIS DOCUMENT.

NOTE: THE AN4-20A BOLTS MAY BE SUBSTITUTED FOR LONGER/SHORTER BOLTS OR ADDITIONAL AN960JD416 WASHERS CAN BE INSTALLED UNDER THE NUT TO ENSURE 1.5-4 THREADS IN SAFETY.

QTY	Part No.	Description
X	DSI-9055-011	STEP CONVERSION KIT
2	D2171	CLAMP
2	D2182W035	CUSHION
4	D2274	CLAMP PAD
1	D2362-3	SUPPORT BRACKET
4	AN4-20A	BOLT
4	AN960JD416	WASHER
4	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: _____
D. SHEPHERD (DE # 02)

DATE: 06.06.07
CERT. NO.: SH92-6
ISSUE NO.: 10

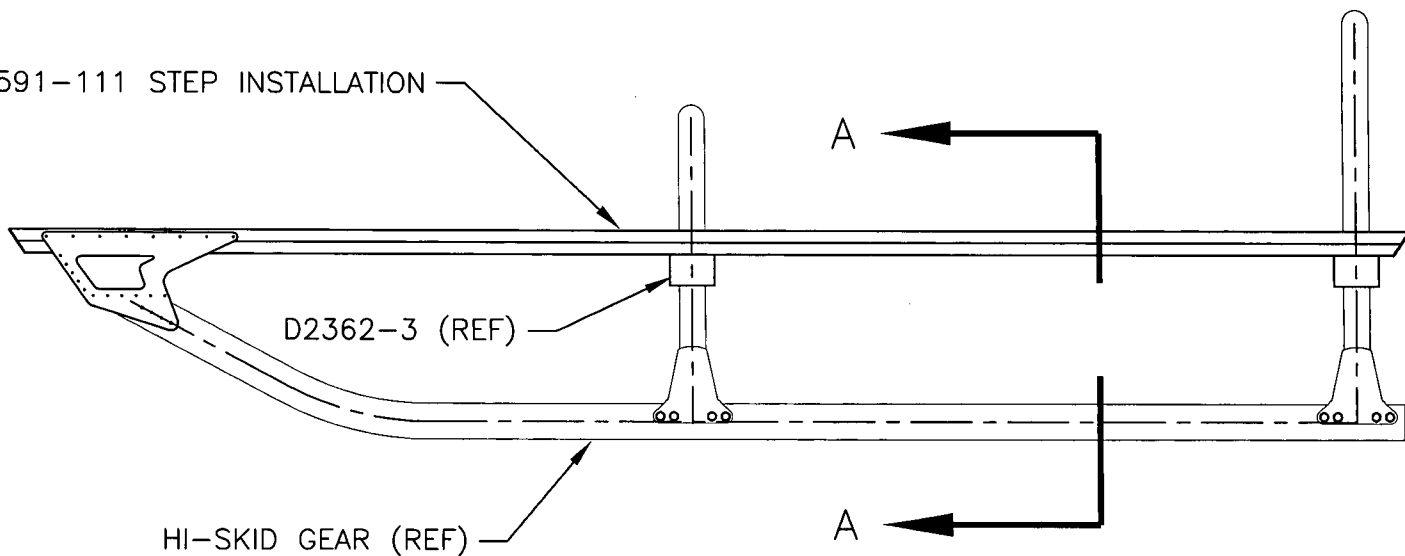
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PRELIMINARY ISSUE

DART

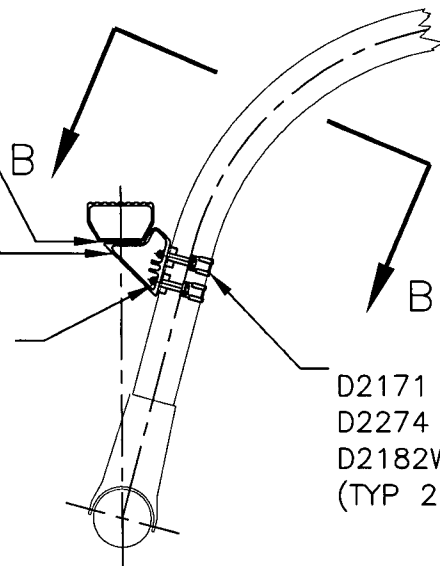
DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE LTD	REV. C
CHECKED	CP	APPROVED		DRAWING NO.	
DATE	06.06.07			DSI 9055	SHEET 2 OF 2
				TITLE	SCALE
				OPTIONAL SUPPORT ADDITION	NTS



POSITION SUPPORT
TO CONTACT
BOTTOM OF STEP

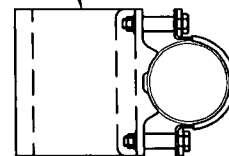
D2362-3 SUPPORT
BRACKET (1)

AN4-20A BOLT (1)
MS21042L4 NUT (1)
AN960JD416 WASHER (1)
(TYP 4 PLACES)



SECTION A-A
NOT TO SCALE

D2362-3 (REF)



SECTION B-B
NOT TO SCALE

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	D. SHEPHERD (DE # 02)
DATE:	06.06.07
CERT. NO.:	SH92-6
ISSUE NO.:	10

Linda Lacelle

From: Kim Johnston [kjohnston@dartaero.com]
Sent: Wednesday, June 07, 2006 1:23 PM
To: Linda Lacelle (E-mail)
Subject: FW: DSI 9055

The new dsi kit will be called DSI-9055-011. Should we be revising the original estimate (DSI 9055) up to rev C and rename it or creating a new estimate (DSI 9055-011) and supercede the old one?

-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]
Sent: Wednesday, June 07, 2006 1:09 PM
To: 'Linda Lacelle'
Subject: RE: DSI 9055

Serge is updating dsi9055 to rev. C to make it a conversion kit to give customers the extra support for their old steps. It will not include the step or the spacers. This means the workorder will have to be updated to remove the spacers (I'm going to do it and re-issue the workorder for you right now). You should be able to pick your kits and, hopefully, the updated dsi will be ready tomorrow.

Kim

-----Original Message-----

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, June 07, 2006 11:21 AM
To: 'Kim Johnston'
Cc: *David Shepherd (E-mail)
Subject: RE: DSI 9055

All I know is that they want to ship tomorrow

-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]
Sent: Wednesday, June 07, 2006 11:05 AM
To: Linda Lacelle (E-mail)
Subject: FW: DSI 9055

What did I tell you about David coming back with something afterwards. Take a look before Serge makes of decision please.

Kim

-----Original Message-----

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: Wednesday, June 07, 2006 10:05 AM
To: 'Kim Johnston'
Cc: 'S Shahbazian (E-mail)'
Subject: RE: DSI 9055

See DSI 9065 Rev. C. D2346 spacer removal covered off for D350-591-111A.

We have options.

A) We could include a copy of DSI 9065 Rev. C with DSI 9055 kit and update BOM and estimate to remove D2346 spacers.

OR

B) We could update DSI 9055 to remove D2346 spacers

- Option A) is technically correct, maybe just a little confusing for customers. Option B) will require some effort by engineering, but will make things easier for the customer.

I leave it to you and Serge to decide which way to go. If it were up to me, I would probably go option B) because its easier for customers.

David

-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]
Sent: Tuesday, June 06, 2006 2:28 PM
To: David Shepherd (E-mail)
Subject: FW: DSI 9055
Importance: High

David,

Sorry to bother you about this again but could you tell me what should be done about this.

Kim

-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]
Sent: Monday, June 05, 2006 3:11 PM
To: David Shepherd (E-mail)
Cc: Toppin Chantelle (E-mail)
Subject: FW: DSI 9055

Hi David,

I have a workorder for DSI 9055 which adds additional support bracket D2362-3 on Fwd xtube for additional step support for the D350-591-111A. This DSI has been incorporated into 591 installation instructions and no longer requires D2346 spacer according to fig 9 section C-C on page 10 of installation instructions. Should the spacers still be included in the kit.

Also, the DSI master was never superceded when it was incorporated into 591 installation instructions but is no longer included in the bluefiles. Chris and I believe that the customer should get the 591 bluefiles, but I'm not sure if we should include a copy of the DSI (which mentions the spacer).

Can you help me out please.

Kim

-----Original Message-----

From: Chantelle Toppin [mailto:chantelt@dartaero.com]
Sent: Monday, June 05, 2006 2:55 PM
To: Kim Johnston
Cc: Chris Provencal (E-mail)
Subject: Re: DSI 9055

Hello Kim,

I pasted the customer's email below for your reference:

"we currently have a AS350B2 and AS355N with your long access steps and we have just purchase a brand new AS350B2 also with your full length access step. I notice on the new aircraft that there is a support clamp and lug on the fwd cross tube which prevents the flexing of step. The older aircraft

1997 vintage don't have this support clamp on the fwd cross tube. Is it possible to purchase just this part of the kit for the access step and if so how much and how long to deliver"

Let me know if you have any further questions.

Thanks,

Chantelle Toppin

Tele: 246 420 7282

Fax: 246 420 7245

----- Original Message -----

From: "Kim Johnston" <kjohnston@dartaero.com>

To: "Toppin Chantelle (E-mail)" <chantelt@dartaero.com>

Cc: "Chris Provencal (E-mail)" <cprovencal@dartaero.com>

Sent: Monday, June 05, 2006 10:55 AM

Subject: DSI 9055

> Hi Chantelle,

>

> I have a workorder for a DSI 9055 which amended the installation
> instructions for D350-591 steps. This DSI was incorporated into the
> installation instructions for revision E dated 2002.09.24. We are now
> at revision F for these instructions.

>

> Can you tell me the reason for this order please. I will need to get
> the workorder updated to reflect latest revision of the DSI if we need
> to provide this to you.

>

> Kim Johnston

> Dart Aerospace Ltd.

> Engineering Clerk

> Document Control

> Work Email: kjohnston@dartaero.com

> Work Tel: 613-632-3336

> Work Fax: 613-632-4443

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